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D2563
Job Sheet 168466



Part No: D2563

Job Qty: 4 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/7/17	12/7/17	0.00	0.00	Start Up Large Fab-2		
100	Large Fab	4 pcs	12/7/17	12/7/17	0.00	5.88	Large Fab 2		17-11-24
110	QC	4 pcs	12/7/17	12/7/17	0.00	0.00	QC9		17-11-24
120	QC	4 pcs	12/7/17	12/7/17	0.00	0.00	QC5		17-11-24
130	HandFinish	4 pcs	12/7/17	12/7/17	0.00	1.07	HandFinish1		2017 DEC 27 250
140	QC	4 pcs	12/7/17	12/7/17	0.00	0.00	QC7		38
150	Large Fab	4 pcs	12/7/17	12/7/17	0.00	5.88	Large Fab 2		17-11-28
160	QC	4 pcs	12/7/17	12/7/17	0.00	0.00	QC10		17-11-28
170	QC	4 pcs	12/7/17	12/7/17	0.00	0.00	QC5		17-11-28
175	HandFinish	4 pcs	12/7/17	12/7/17	0.00	1.07	HandFinish2		2017-11-28 250
180	Powdercoat	4 pcs	12/7/17	12/7/17	0.00	0.67	Powdercoat1		PR 17-11-20
190	HandFinish	4 pcs	12/8/17	12/8/17	0.00	1.07	HandFinish3		BEB 17/12/05
200	QC	4 pcs	12/8/17	12/8/17	0.00	0.00	QC3		38
210	Packaging	4 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3		38
220	QC21-SA	4 Ea	12/8/17	12/8/17	0.00	0.00	QC21		DEC 06 2017

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & DESCRIPTIONS: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind

150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind

175 - Touch up Alodine as per QSI005

180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 11:50

OUT: 320 FINISH 12-00
11/13/8467

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2244-116 150064	4	105	0	0
	D2561 160297 (6x)	8	26	0	0
	D2564 160325	8	15	0	0
	D2673-34 160473	4	15	0	0
150-Large Fab	D2673-34	4	15	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: 16846

Part No. 02503

NCR No. 19-7338

DISPOSITION

Rework ☒
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Thermoforming ☐
Large Fab ☒
Cross tube ☐
Small Fab ☐
Finishing ☐
Composite ☐
Water Jet ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Supplier ☐

Engineering ☐
Quality ☐
Other ☐

Date: 11-11-30 Step #: 150

QTY Effective: 1

MRB (QS1042) Approval 10-11-30
5/18/2019

Description Work Order Deviation

Disposition

forbin object found inside step after
paint ~~150~~

drill small hole in corner of
cap to remove fob.
weld hole grind flush
Scuff entire step and
repowder coat.

Completed By
12-11-30
12-11-30

Lead hand / Supervisor
Approval Verification
DAS
24

JUL 16 2019

QC / QA Coordinator
Approval
DAS
40

JUL 16 2019

Root Cause

FAULT CATEGORY

Environment ☐
Design ☐
Doc/Data ☐
Equip/Tooling ☐
Handling/Pre ☐
Material ☐
Internal Transport ☐
Tribal Knowledge ☐
LOA ☐
Substation ☐
Past Expiry Date ☐
Misidentified ☐

No Re-verification ☒
Operator ☐
Offset/Setup ☐
Supplier ☐
Training ☐
Use for Testing ☐
Poor Information ☐
Rushing ☐
Product Improvement ☐
Process Improvement ☐
Manufacturing Process ☐
Past Due ☐

Pressure/Forced ☐
Bending ☐
Centre Not Concentric ☐
Cracks ☐
Crimp/Kink/Ripple/Wave ☐
Cuffs ☐
Crushing ☐
Heat Treat ☐
Wave/Twist in Tube ☐
Marks/Chatter ☐

Temperature/Cure ☐
Set-up ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Inspection Incomplete/Unqualified ☐
Contamination ☐
Countersink ☐
Cut Too Short ☐
Instructions Incomplete/Unclear ☐
Drill Holes ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set ☐
Misaligned ☐
Fit/Function ☐
Misaligned/off center ☐

Positioned Wrong ☐
Outside Dimensions ☐
Over/Under tolerance ☐
Part Incorrect ☐
Part Lost/Missing ☐
Part Moved ☐
Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐

OTHER: F.O.D.